

# Work Order ID 123702

September-16-14 12:35:17 PM

**\*123702\***

Page 1

Item ID: D2435 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Bearpaw  
 Start Date: 8/18/14 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 8/18/14 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: ✓ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2435	Rev E1								

105 0.00

**\*105\***

Purchasing

Purchasing

Memo

ISSUE PO 25836  
Cut Blank per D2435 file

0.00

CD 14/10/18 4

110

Receive & Inspect for Damage & Mat'l Certs

0.00

**\*110\***

Packaging

Packaging

Memo

0.00

14/10/201 (4)

115

QC6- Inspect dimensions to drawing

0.00

**\*115\***

QC

Quality Control

Memo

0.00

CD 14/10/22 4 0

**\*123702\***

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**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 8/18/14      **Start Qty:** 4.00

**\*4\***

**Cust Item ID:**

**Required Date:** 8/18/14      **Req'd Qty:** 4.00

**\*4\***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_  
**QC:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **SPC (Y/N):** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
<b>*130*</b>	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	<b>Memo</b>	0.00				<u>4</u>	<u>Ø</u>		JFC 2014-10-23
HAAS CNC vertical machine #1									
1-Inspect material for defects or damage prior to machining									
2-Machine as per Folio FA789 and Dwg D2435 Identify as D2435									
3-Deburr									
140		0.00							
<b>*140*</b>	QC2- Inspect parts off machine FAI/FAIB								
QC	<b>Memo</b>	0.00				<u>4</u>	<u>Ø</u>		JFC 2014-10-23
Quality Control									
150		0.00							
<b>*150*</b>	QC8- Inspect parts - second check								
QC	<b>Memo</b>	0.00				<u>4</u>	<u>Ø</u>		DAS 37 14.10.24 9-89
Quality Control									

# Work Order ID 123702

**\*123702\***

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Item ID: D2435  
 Revision ID:  
 Item Name: Bearpaw  
 Start Date: 8/18/14 Start Qty: 4.00 **\*4\***  
 Required Date: 8/18/14 Req'd Qty: 4.00 **\*4\***  
 Reference:

Accept **\*N900040100\***  
 Setup Start **\*NS1\***  
 Stop **\*NS2\***  
 Cust Item ID:  
 Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***  
 Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
151	Identify as per dwg & Stock Location: _____	0.00							
<b>*151*</b>									
Packaging	Memo	0.00				4	DAS 66 9-89		
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
<b>*190*</b>									
QC	Memo	0.00							
Quality Control									

14/11/3

14-11-03

# Picklist Print

Monday, August 18, 2014 2:37:04 PM

Page 1

Work Order ID: 123702

**\*123702\***

Parent Item: D2435

**\*D2435\***

Parent Item Name: Bearpaw

Start Date: 8/18/14

Required Date: 8/18/14

Start Qty: 4.00

Required Qty: 4.00

## Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	432.0000	3.2	13			
<b>*MUHMWB10*</b>									<b>**</b>	<del>A129293</del> CL14/10/03			
UHMW 1" Black - 48"x120" Tivar Mfg.#52480104										<del>A130421</del>			
						<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
						MAT014		432					
						m128267		47					
						m128668		313.3					
						m129293		71.7		13			

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other
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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 123702
<b>Description:</b> Bearpaw		<b>Part Number:</b> D2435
<b>Inspection Dwg:</b> D2435	<b>Rev:</b> E1	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.063	✓		depth g	JFL-07
B	5.500	+/-0.030	5.499	✓		Caliper	JFL-01
C	0.200	+/-0.030	0.190	✓		depth g	SL-11
D	R0.250	+/-0.030	0.250	✓		rad g	Stop
E	0.250	+/-0.010	0.250	✓		mic o1	JFL-02
F	0.625	+/-0.030	0.626	✓		Caliper	JFL-01
G	0.25 x 45°	+/-0.030	0.25 x 45°	✓		depth g	JFL-07
H	0.375	+/-0.010	0.384	✓		Caliper	JFL-01
I	19.000	+/-0.030	19.00	✓		tape	JFL-06
J	0.950	+0.030/-0.010	0.959	✓		mic o1	JFL-02
K	Ø0.260	+0.005/-0.000	0.260	✓		Caliper	JFL-01
L	Ø0.930	+/-0.030	0.929	✓		Caliper	JFL-01
M	0.30	+0.030/-0.000	0.312	✓		depth g	SL-11
N	0.375	+/-0.030	0.380	✓		Caliper	JFL-01
O	7.375	+/-0.030	7.378	✓		"	ENC-02
P	4.250	+/-0.010	4.250	✓		"	"
Q	2.000	+/-0.030	1.996	✓		"	"
R	9.000	+/-0.010	8.998	✓		"	"
S	15.750	+/-0.030	15.750	✓		tape	JFL-06

DAS

<b>Measured by:</b> JFL	<b>Audited by:</b> 37 9-89	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 2014-10-23	<b>Date:</b> 14.10.24	<b>Date:</b>	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O K10007	KJ/RF	✗

Copyright 1996 by DART AEROSPACE LTD

Et	02.12.17	$\phi 0.93$ WAS $\phi 0.75$	RE
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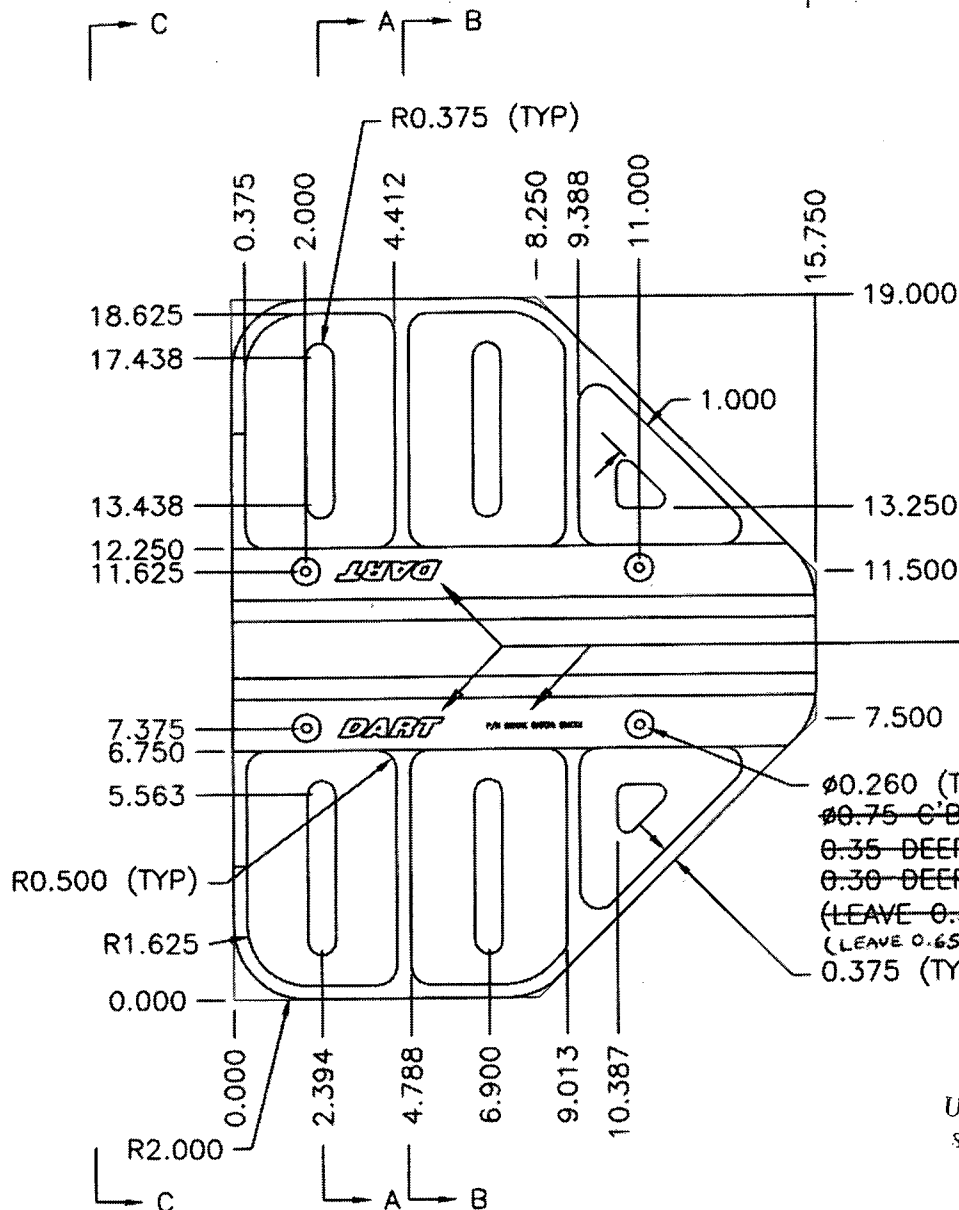
RELEASED  
1986-06-17 KEE



**DA RT**



DESIGN BY KE		DRAWING NO. D2435		REV. E	
CHECKED KE		APPROVED KE		SHEET 1 OF 2	
DATE 98.05.19		TITLE BEARPAW		SCALE 1:5	
A	96.01.24	NEW ISSUE			
B	96.03.26	CHANGE BORE AND C'BORE DEPTH			
C	97.05.07	CHANNEL & C'BORE DEPTH CHANGED			
D	97.10.17	R1.5 BORE WAS R2.637 (TSR A469)			
E	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50			

ENGRAVE LOGO TO MAX  
DEPTH OF 0.012. ENGRAVE  
PART AND BATCH NUMBERS  
TO MAX DEPTH OF 0.010.  
(TYPICAL LOCATION AS  
ILLUSTRATED)



~~Ø0.260 (TYP) Ø0.93 C'BORE~~  
~~Ø0.75 C'BORE 0.30 DEEP FROM BOTTOM~~  
~~0.35 DEEP FROM TOP (MIN.)~~  
~~0.30 DEEP FROM BOTTOM~~  
~~(LEAVE 0.300 MIN.)~~   
~~(LEAVE 0.650 MIN.)~~  
~~0.375 (TYP)~~ 

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 123707 MCT

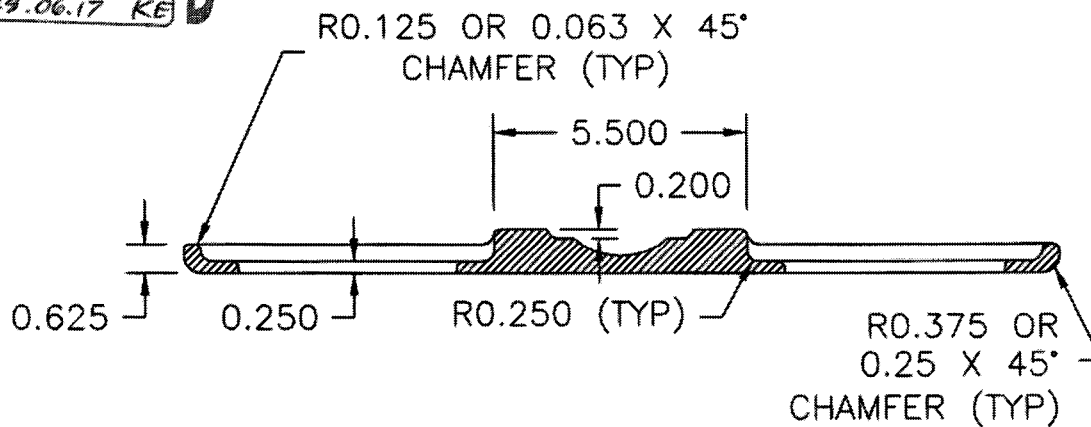
MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689  
1.00 THICK (MACHINE TO 0.950)

14-08-10

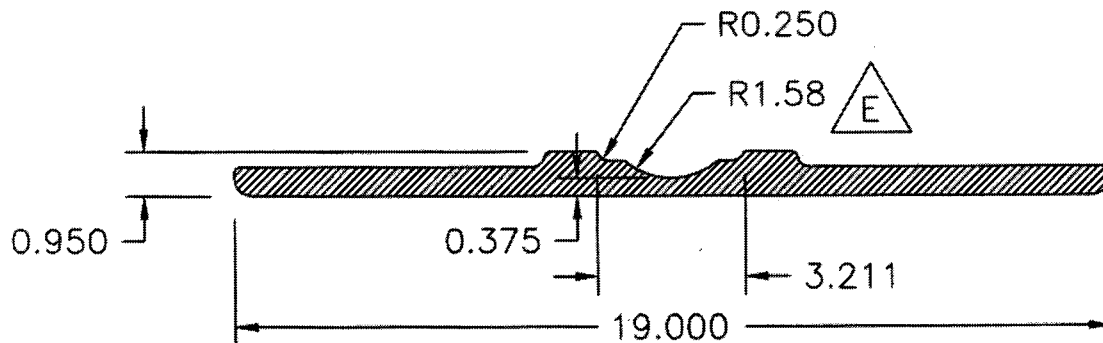


DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>DM</i>	APPROVED <i>KE</i>	DRAWING NO. D2435	REV. E SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

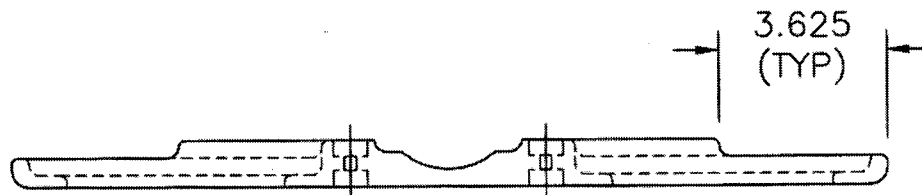
RELEASED  
99.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C



**T.P.I. INDUSTRIES INC.**

148 GOODFELLOW  
DELSON, QUÉBEC J5B 1V4  
CANADA  
Tel: (450) 633-0484  
Fax: (450) 633-0879

**Packing Slip**

Packing Slip No.: 6316  
Date: 2014-09-29  
Page: 1

<b>Sold to:</b>  <b>Dart Aerospace</b> Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada	<b>Ship to:</b>  <b>Dart Aerospace</b> Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada
<b>Order No.:</b> 100810	<b>Sold By:</b> JONATHAN LESSARD
<b>Shipped By:</b>	<b>Ship Date:</b> 2014-09-29
<b>Tracking No.:</b>	

Item No.	Unit	Description	Quantity
d2432-3	Chaque	d2432-3 bearpaw	2
d2435	Chaque	d2435 bearpaw	18
d2521	Chaque	d2521 bearpaw	22
d2432	Chaque	d2432 bearpaw	15
d4930-1	Chaque	d4930-1 bearpaw	8
d4355-1	Chaque	d4355-1 bearpaw	7
d4353-041	Chaque	d4353-041 bearpaw	2
d4297-1	Chaque	d4297-1 bearpaw	2
d2995	Chaque	d2995 bearpaw	2
		00-2521-3	
<b>Comment:</b> Des frais d'intérêts de 2% / mois seront chargés sur tout compte passé du après 30 jours			